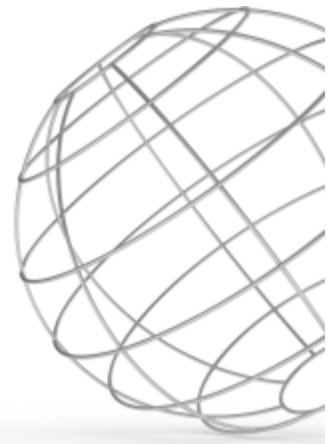




R656.20

EN: 23 7 NL
AWS:



R656.20 is a duplex welding grade primarily designed for welding of the Lean duplex grade LDX 2101® (Developed and patented by Outokumpu) (EN1.4162) but can also be used for welding of SAF 2304® (Trademark owned by Sandvik Group) (EN 1.4362). The duplex microstructure gives a high tensile strength, a good general corrosion resistance and very good resistance towards stress corrosion cracking.

CHEMICAL COMPOSITION (Nominal) %

C	Si	Mn	Cr	Ni	Mo	N		
<0.025	0.60	1.00	23.5	7.7	<0.5	0.140		

PRE: 28 (PRE = Cr + 3.1 x Mo + 25 x N)

Comments: Ferrite: 44 FN WRC-92

THERMAL TREATMENT

Annealing temperature	1020-1080 °C
	1870-1980 °F

MAX. OPERATING TEMPERATURE

Operating temp. in air	max. 300 °C
	570 °F
Scaling temp. in air	850 °C
	1560 °F

TYPICAL MECHANICAL PROPERTIES

Condition: D-cooled or DST-annealed (Direct Solution Treatm.)

Proof strength	Rp0.2	min. 480 N / mm ²
Tensile strength	Rm	730-830 N / mm ²
Elongation	A10	min. 30 %

DEFORMATION GRAPH

